

Date: Friday, 02/01/2009 8:39:31 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 44349	
Estimate Number : 11218	
P.O. Number :	Part Number : D34173
This Issue : 02/01/2009 S.O. No. :	Drawing Number : D3417 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 42176	Material :
Written By : <u>JS 09-01-02</u>	Due Date : 09/01/2009 Qty: <u>60</u> Um: Each
Checked & Approved By :	
Comment : Est Rev:A 05.10.19 New issue KJ/EC	
Est Rev:B 05.10.19 added haas op. EC	
Est Rev:C As per Rev D 08-07-09 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDEL RIN R12500 DELRIN ROUND BAR 1.25"



0.0446 P(s)

1.3399 P(s)



Comment: Qty.: 0.0511 (s) Unit Total: 0.9324 (s)  
 Material: Delrin Round Bar Ø1.250  
 (M-DELRIN-R1.250)  
 Batch: M110256  
 Identify for D3417-3

SA 09/01/03

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan lathe

1-Turn as per Folio FA594 Rev: N/A & Dwg D3417 Rev: D

2-Deburr

SA 09/01/03

60

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/01/03

60

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JS 09/01/05

60

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 91

JS 09/01/05

60

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 44349

Part Number: D34173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(60)

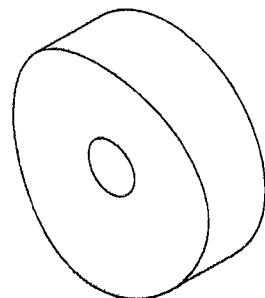
Comment: FINAL INSPECTION/W/O RELEASE

209/01/06

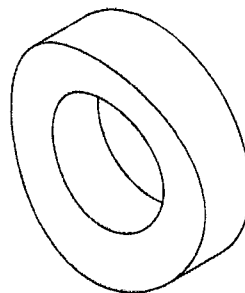
Job Completion



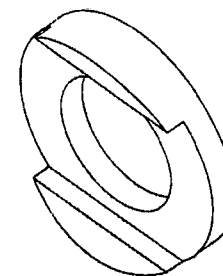
MF 09-01-05



**D3417-1 WASHER**



**D3417-3 WASHER**



**D3417-5 WASHER**



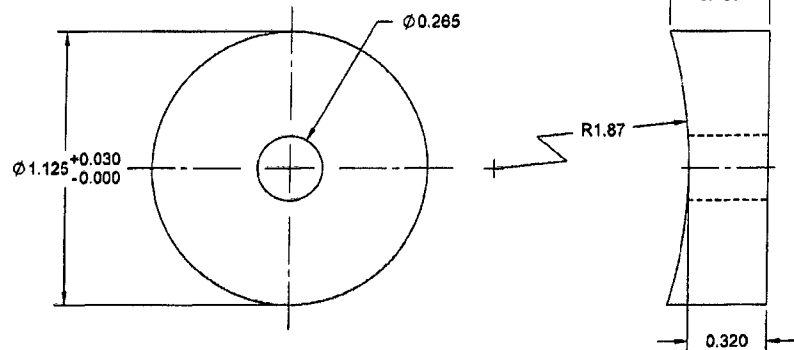
*6/10/08  
664349*

**RELEASED**  
06-08-01/14

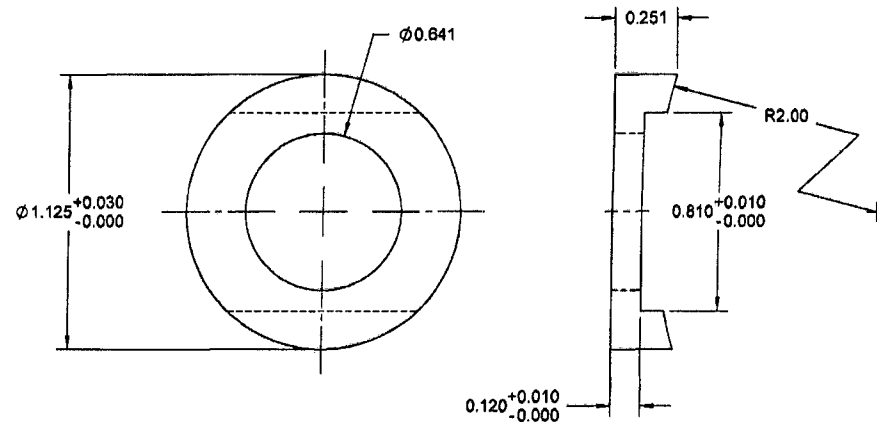
**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELRIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELRIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.02 lbs  
D3417-3, 0.01 lbs  
D3417-5, 0.01 lbs

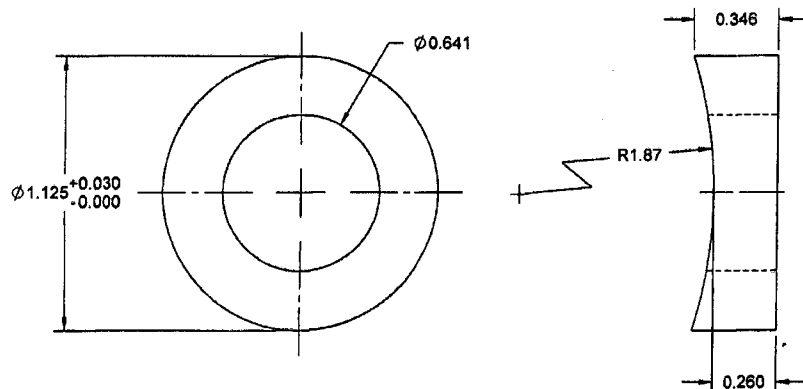
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	<b>D3417</b>	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>WASHER</b>	NTS
DATE	08.07.08	COPY RIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



**D3417-1 WASHER**



**D3417-5 WASHER**



**D3417-3 WASHER**

**RELEASED**  
08-08-08

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3417	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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